

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015011**Date Inspected:** 18-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Out Side

This QA Inspector observed the following work in progress:

SMAW in the 3G position for the OBG Segment 11DE , weld No. SEG072D-082. The welder is identified as #054013. ZPMC QC is identified as Mr. Tang Ya Jun. The welding variables recorded by QC appear to comply with WPS-B-P-2213-Tc-U4b-FCM-1.

SMAW in the 4F position for the OBG Segment 11DW, weld No. OBW11E-048/049. The welder is identified as #067609. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-B-T-2114-FCM-1.

FCAW in the 3G position for the OBG Segment 11DE , weld No. SSD16-PP104-245. The welder is identified as #058551. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-B-T-2233-Tc-U4b-F.

Bay #14

This QA Inspector observed the following work in progress:

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SAW in the 1G position for the OBG Segment 13AE bottom Plate, weld No. BP3033-001-002. The welder is identified as #044771. ZPMC QC is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-U3c-S-2.

FCAW in the 2F position for the OBG Segment 13CE side Plate to stiffener , weld No. SP3066A-001-029~038. The welders are identified as #044830/044795. ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

Bay #16

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG Segment 13AW bottom Plate, weld No. BP3074-001-005. The welder is identified as #045265. ZPMC QC is identified as Mr. Xia Chan Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-U3c-S-2.

Bay #19

This QA Inspector observed the following work in progress:

FCAW in the 4F position for the OBG Bike Path BK004A weld No. BK004A6-003-023/024. The welder is identified as #500909. ZPMC QC is identified as Mr. Zhoe Chang. The welding variables recorded by QC appear to comply with WPS-B-T-2134.

Ultrasonic Testing (UT)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as suspender brackets.

The weld designation reviewed is as follows:

SB013-068-001,004,005,007,008,025,037,049,061

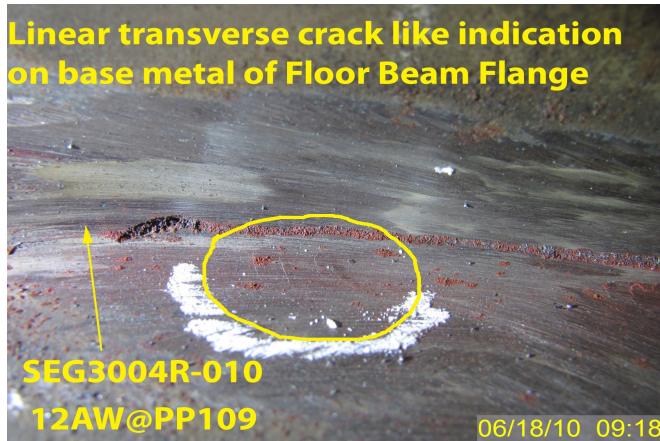
During random visual inspection at segment 12AW on Panel Point PP109, the QA Inspector found the linear transverse crack like indication on several locations at the base metal of Floor beam flange .The mention area was not welded due to tack weld crack at bay #14. Then the QA Inspector informed to ZPMC QC Personnel to perform Magnetic Particle Testing at mention area and more than 90% of the crack tack area found linear transverse indication on base metal of Floor Beam Flange.The QA inspector informed to ZPMC QC Mr. Li Ping and ABF QA Mr. Wen Jian Bao to remove the indication and do Magnetic Particle Testing for confirmation at those mention area. For more information see the attached photo.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Linear transverse crack like indication
on base metal of Floor Beam Flange



ZPMC personnel performing fit up the side plate
SP3092B to stiffener RS3086F at Bay#14



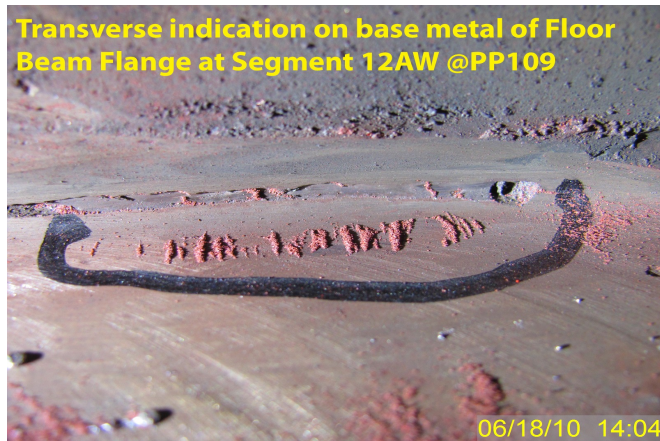
ZPMC personnel performing FCAW for weld joint BK004A6-003-023
at 4F position on Bkr Path BK4A-003



ZPMC personnel performing SAW for splice weld
joint BP3074-001-005 at 1G position on 13AW



Transverse indication on base metal of Floor
Beam Flange at Segment 12AW @PP109



Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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Inspected By: Bera,Subhasis

Quality Assurance Inspector

Reviewed By: Patterson,Rodney

QA Reviewer